

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020971**Date Inspected:** 11-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu hua jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this date Caltrans Office of Structural Material (OSM) Quality Assurance (QA) Inspector, D.Sukanthan was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

OBG # BAY 16

This QA observed ZPMC qualified welding personnel identified as 067752 perform Flux Cored Arc Welding (FCAW) Process on weld joint BP3095-001-025. ZPMC Quality Control Personnel (QC) identified as Mr. Peng wen jan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA observed ZPMC qualified welding personnel identified as 067752 perform Flux Cored Arc Welding (FCAW) Process on weld joint BP3095-001-007,008. ZPMC Quality Control Personnel (QC) identified as Mr. Peng wen jan was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2132-ESAB. See attached pictures.

OBG # SEGMENT 13BW

This QA observed ZPMC qualified welding personnel identified as 04522 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3014D-350. ZPMC Quality Control Personnel (QC) identified as Mr. Qui

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wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA observed ZPMC qualified welding personnel identified as 067888 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3014D-350. ZPMC Quality Control Personnel (QC) identified as Mr. Qui wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA observed ZPMC qualified welding personnel identified as 201583 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3014B-021. ZPMC Quality Control Personnel (QC) identified as Mr. Qui wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-ESAB.

This QA observed ZPMC qualified welding personnel identified as 066695 perform Flux Cored Arc Welding (FCAW) Process on weld joint SEG3014B-021. ZPMC Quality Control Personnel (QC) identified as Mr. Qui wen was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-B-T-2232-ESAB.

### OBG # SEGMENT 14E

This QA observed ZPMC qualified welding personnel identified as 066422 perform Shielded Metal Arc Welding (SMAW) Process on weld joint SEG3019D-323. ZPMC Quality Control Personnel (QC) identified as Mr. Guo xing hui was present to monitor the welding process. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW-2G (2F)-FCM-Repair -1 and Critical Weld Repair B-CWR2678.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

As mention above

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### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-00422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Sukanthan,Dhanasingh	Quality Assurance Inspector
<b>Reviewed By:</b>	Hall,Steven	QA Reviewer

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